

312cd

**Work Order ID 119154**

May-12-14 9:14:36 AM

**\*119154\*** RLL

Page 1

Item ID: D205-634-145

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: W

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2580-049

G

IIN-D205-634

REV H

100

Document Control

0.00

**\*100\***

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

N/A MJS 14-08-21

110

Skidtubes

0.00

**\*110\***

Skidtubes

Memo

0.00

Skidtubes

1- PICK D2580-1

2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021,  
DRILL 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF.  
ONLY)

> JLL / DOC 14-5-20

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**\*119154\***

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Item ID: D205-634-145

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

**\*120\***

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT 16

2-Cut tubes as per Dwg. D2580

3- Scribe batch# in aft end of tube

130

0.00

**\*130\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required.

2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7.

3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7.

4-Drill pilot holes for aft cap using DT8215, Open to finished size.

14-5-20 JH/DC

05/19/20

# Work Order ID 119154

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**\*119154\***

Page 3

Item ID: D205-634-145

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
140	QC5- Inspect part completeness to step on W/O	0.00								
<b>*140*</b>										
QC	Memo	0.00								
Quality Control										
150		0.00								
<b>*150*</b>										
Skidtubes										
	Memo	0.00								
Skidtubes	1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod <i>m127763</i>									
	2-Touch up alodine on run on wearplate holes prior to swaging <i>14-5-21 JLDGL</i>									
	3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg									
	4-DRILL TOWING HOLE USING DT8091									
	5-DEBURR									

DAS  
18  
9-89

*02 14/05/27*

# Work Order ID 119154

May-12-14 9:14:36 AM

**\*119154\***

Page 4

Item ID: D205-634-145

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Pressure Wash per QSI005 4.3	0.00							
<b>*180*</b>									
HandFinish	Memo	0.00							
Hand Finishing	And realodine tube as per QSI 005								

1 76146-4

# Work Order ID 119154

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Item ID: D205-634-145 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube with Thru-Bolt Wearplates  
 Start Date: 5/12/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	<del>White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum</del> <b>Black Sandtex</b>	0.00							
<b>*190*</b>	Memo <b>11/27/89</b>	0.00							
Powdercoat	START TIME: <b>10:15</b>								
Powder Coating	OVEN TEMPERATURE: <b>320</b>								
	FINISH TIME: <b>10:45</b>								
200	QC3- Inspect Part Finish	0.00							
<b>*200*</b>	Memo	0.00							
QC									
Quality Control									

**1** **6-27** **12:34**

**1341** **11/07/14**

# Work Order ID 119154

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May-12-14 9:14:36 AM

Item ID: D205-634-145 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Replacement Skidtube with Thru-Bolt Wearplates  
 Start Date: 5/12/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/30/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Assemble as per dwg	0.00							
*210*	HandFinishing								
Hand Finish	Memo	0.00							
Hand Finishing	1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 11123979 Sikaflex expire date: 1510								
	2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 RTU 59813612 11123972 exp 15/10								
	3- Install aft cap as per dwg								
	4- Wing walk as per dwg Batch# 11123979 6								
220	QC5- Inspect part completeness to step on W/O	0.00							
*220*									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								

1341 d 11123979

1 14/08/20 DAS 38 9.80 14/08/20

# Work Order ID 119154

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Item ID: D205-634-145 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube with Thru-Bolt Wearplates  
 Start Date: 5/12/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Packaging	0.00							
<b>*230*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-145								
	Location: _____								
	PPP Rev: _____								
240	QC21- Final Inspection - Work Order Release	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control									

*PP*

DAS  
06  
9-89

AUG 20 2014

1/9/67

MC 14-08-21

14-8-20

# Picklist Print

May-12-14 9:14:34 AM

Page 1

Work Order ID: 119154

**\*119154\***

Parent Item: D205-634-145

**\*D205-634-145\***

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1 Manufactured No

Each 7.0000 1

**\*D2580-1\***

**\*\***

205 Bent Tube

Location

Loc Qty

Loc Code

LG

7

115862

1

117437

6

D4202-1 Manufactured No

Each 230.0000

24

**\*D4202-1\***

**\*\***

Spacer

Location

Loc Qty

Loc Code

LG

227

113770

227

LG001

3

105931

3

D2594-1 Manufactured No

Each 204.0000

8

**\*D2594-1\***

**\*\***

Plug

Location

Loc Qty

Loc Code

FP001

187

110311

47

112516

60

112727

80

FP002

17

106252

17

14-5-20

14/05/27

24

14/07/14

B119830

80



# Picklist Print

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Work Order ID: 119154

**\*119154\***

Parent Item: D205-634-145

**\*D205-634-145\***

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D2576-3

Manufactured No

Each

57.0000

1

**\*D2576-3\***

Step (Machining Detail)

**\*\***

*85,405-21*

Location

Loc Qty

Loc Code

LG

50

112978

50

LG001

7

105581

7

Each

661.0000

8

D2594-3

Manufactured No

**\*D2594-3\***

O-Ring

**\*\***

*all 11/07/14*

Location

Loc Qty

Loc Code

FP001

661

108402

156

110671

2

112234

3

113590

500

Each

50.0000

1

D2855

Manufactured No

**\*D2855\***

Cap

**\*\***

*all 11/07/14*

Location

Loc Qty

Loc Code

FP001

48

105248

6

111897

42

ST019

2

10360

2

*B117281*

*VI*

# Picklist Print

May-12-14 9:14:35 AM

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Work Order ID: 119154

**\*119154\***

Parent Item: D205-634-145

**\*D205-634-145\***

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No

Each 979.0000 2

**\*AN3-5A\***

Bolt

\*\*

211 11/07/14

Location

Loc Qty

Loc Code

GA

45

117423

45

ST511

832

m126559

832

ST512

102

124561

102

x2

NAS1149D0332J

Purchased No

Each 5,499.000

2

**\*NAS1149D0332.J\***

Washer

\*\*

211 11/07/14

Location

Loc Qty

Loc Code

ST294

513

m128606

513

ST510a

4986

m128612

4986

x2

D5061-1

Manufactured No

Each 0.0000

1

**\*D5061-1\***

Fwd Wearplate

\*\*

B117596 (1x) 211 11/07/14

D5061-3

Manufactured No

Each 2.0000

1

**\*D5061-3\***

Aft Wearplate

\*\*

B117597 (1x) 211 11/08/14

Location

Loc Qty

Loc Code

prelim

2

113413

2

May-12-14 9:14:35 AM

Shop Packet Print

Page 3

# Picklist Print

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Page 4

Work Order ID: 119154

**\*119154\***

Parent Item: D205-634-145

**\*D205-634-145\***

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 5/12/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

AN4-45A

Purchased

No

Each

101.0000

8

**\*AN4-45A\***

BOLT

**\*\***

*all 5/30/14*

Location

Loc Qty

Loc Code

ST517

101

m126176

4

m126333

38

m128403

9

m129022

50

*x 8*

D2570

Manufactured

No

Each

477.0000

16

**\*D2570\***

Bushing

**\*\***

*all 5/30/14*

Location

Loc Qty

Loc Code

FG

12

88781

12

*13119457*

*x 16*

ST011

465

108538

188

110735

24

112726

5

113679

48

115735

200

MS21042-4

MS21042L4

Purchased

No

Each

24.0000

8

**\*MS21042-4\***

Nut

**\*\***

*all 5/30/14*

Location

Loc Qty

Loc Code

ST314

24

m2937

12

*1124231*

m8182

12

*x 8*

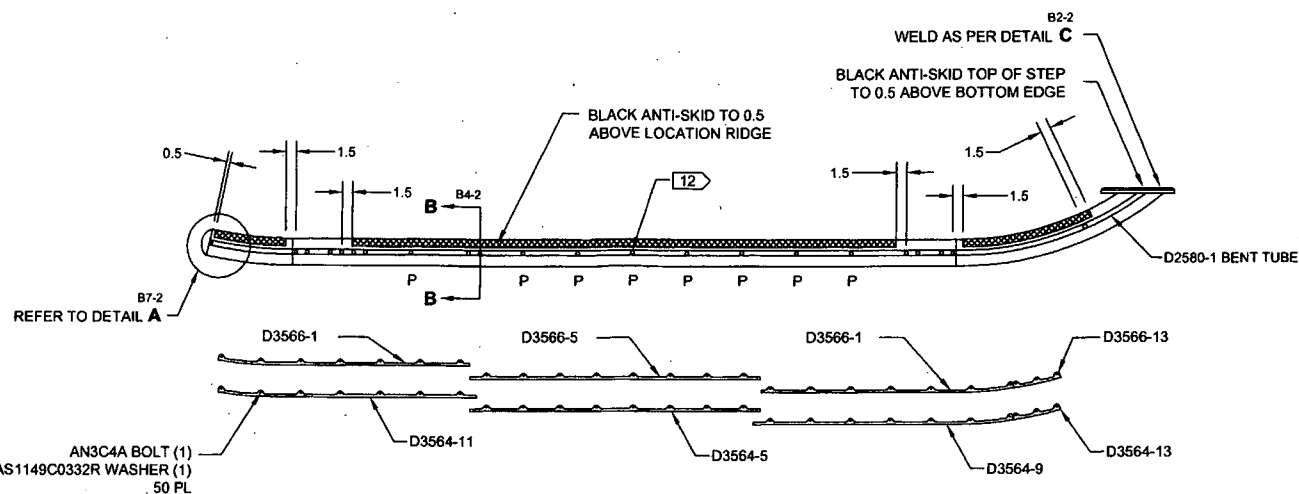
LIST OF MATERIALS						PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	QTY -049			
1	X					D2580-041	SKIDTUBE ASSEMBLY
2		X				D2580-045	SKIDTUBE ASSEMBLY
3			X			D2580-047	SKIDTUBE ASSEMBLY
4				X		D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1		D2500-1-190	EXTRUSION
21			16	16		D2570	BUSHING
22	1	1	1	1		D2576-3	STEP
23		4				D2579	SPACER
24	16	16	8	8		D2594-1	PLUG
25	16	16	8	8		D2594-3	O-RING
26	1	1	1	1		D2596	205 WEB
27	1	1	1	1		D2855	AFT CAP
28	1	1				D3564-5	WEARSHOE
29	1	1				D3564-9	WEARSHOE
30	1	1				D3564-11	WEARSHOE
31	1	1				D3564-13	WEARSHOE
32	2	2				D3566-1	GASKET
33	1	1				D3566-5	GASKET
34	1	1				D3566-13	GASKET
35	20	20	24	24		D4202-1	SPACER
36			1			D4406-041	WEARPLATE ASSEMBLY
37			1			D4406-043	WEARPLATE ASSEMBLY
37				1		D5061-1	FWD WEARPLATE
37				1		D5061-3	AFT WEARPLATE
50	50	50				ALST-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50				AN3C4A	BOLT
52	2	2	2	2		AN3-5A	BOLT
53			8	8		AN4-45A	BOLT
54	50	50				NAS1149C0332R	WASHER (AN960C10L)
55	2	2	2	2		NAS1149D0332J	WASHER (AN960JD10L)
56			8	8		MS21042-4	NUT (OR MS21042L4)

# GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT ASSEMBLY (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 34.5 lbs  
D2580-045 = 34.5 lbs  
D2580-047 = 45.1 lbs  
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 80 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALST-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

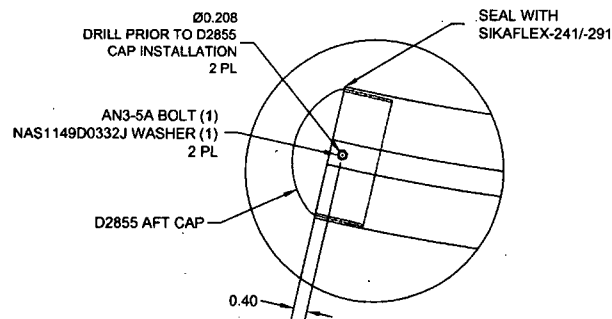
RELEASED  
2014-04-29

G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	DS	D2580	SHEET 1 OF 9
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	205 SKIDTUBE ASSEMBLY	NTS
DATE	14.04.09	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

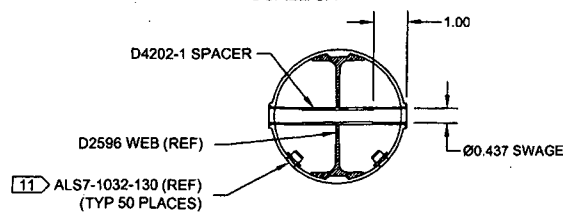


**D2580-041 ASSEMBLY DETAIL**

**DETAIL A** C7-2  
SCALE 5X

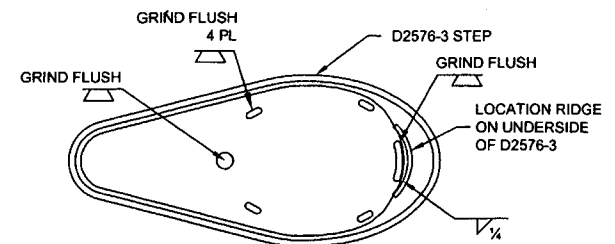


**SECTION B-B** D5-2  
SCALE 5X



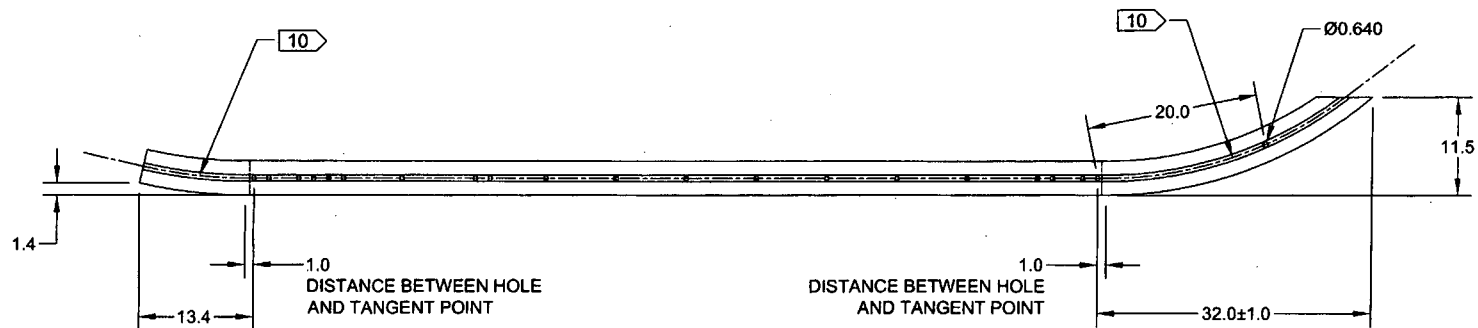
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (20 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

**DETAIL C** D3-2  
SCALE 5X



DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 2 OF 9
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DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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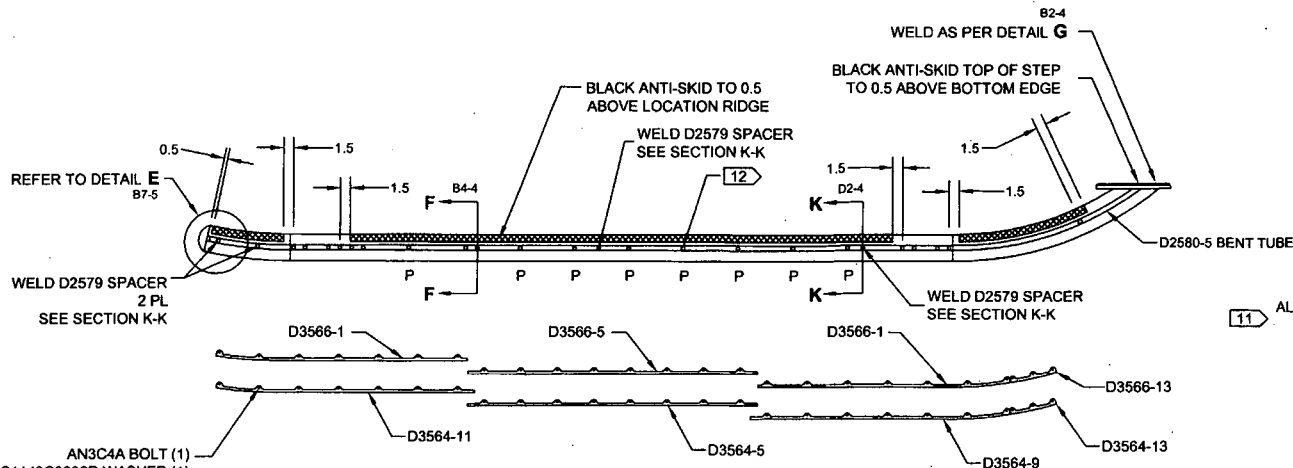


D2580-1 BENT TUBE  
(MAKE FROM D2580-101 TUBE)

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2014-04-29

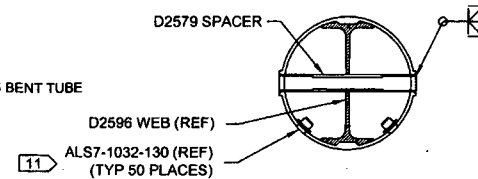
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DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 3 OF 9
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1



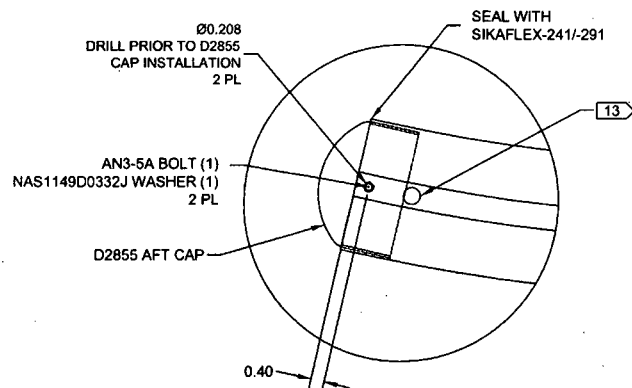
**D2580-045 ASSEMBLY DETAIL**

**SECTION K-K D5-4**  
SCALE 5X

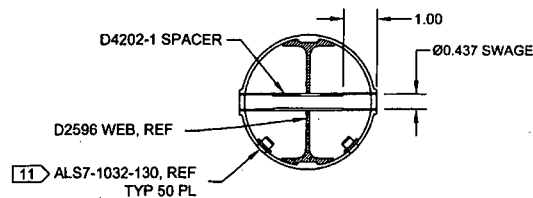


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (4 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. DO NOT C'BORE

**DETAIL E D7-4**  
SCALE 5X

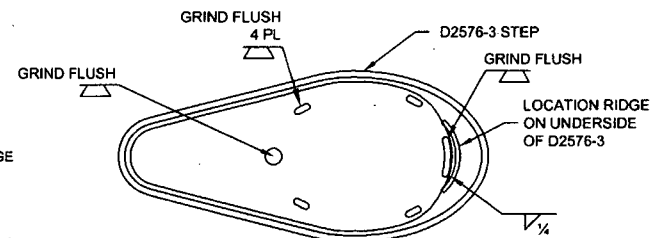


**SECTION F-F D5-4**  
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (20 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM/GRIND FLUSH PER QSI 002

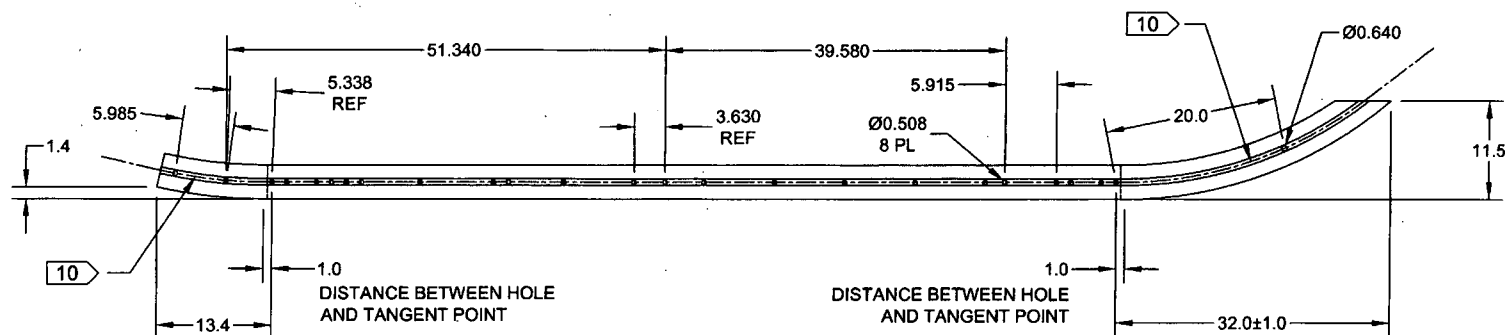
**DETAIL G D3-4**  
SCALE 5X



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DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

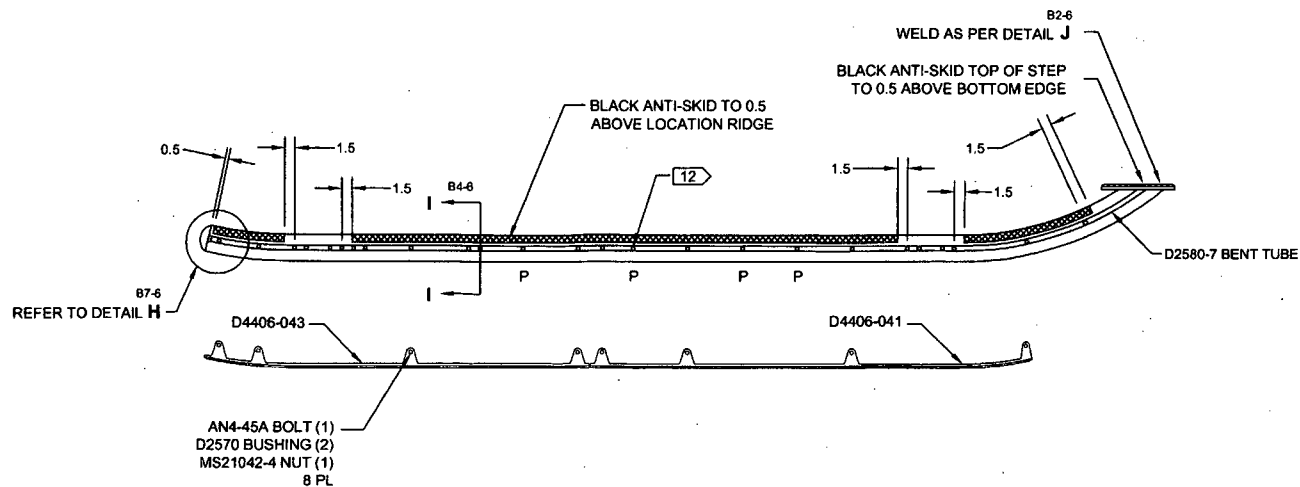


**D2580-5 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

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2014-04-29

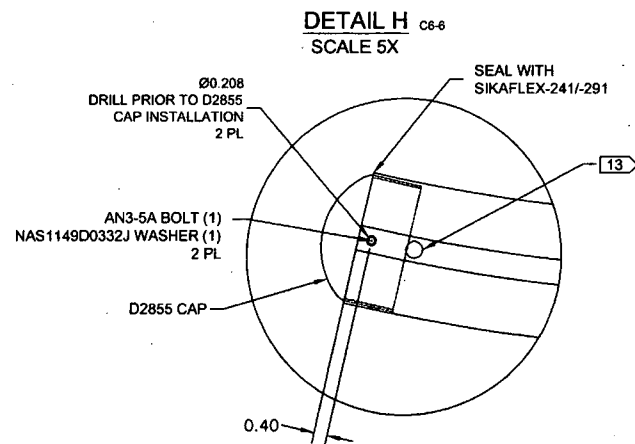
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>AJS</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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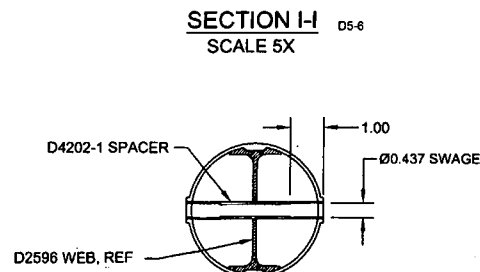


**D2580-047 ASSEMBLY DETAIL**

**RELEASED**  
2014-04-29

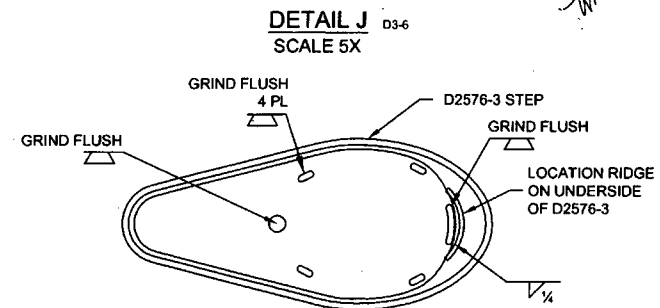


**DETAIL H** C6-6  
SCALE 5X



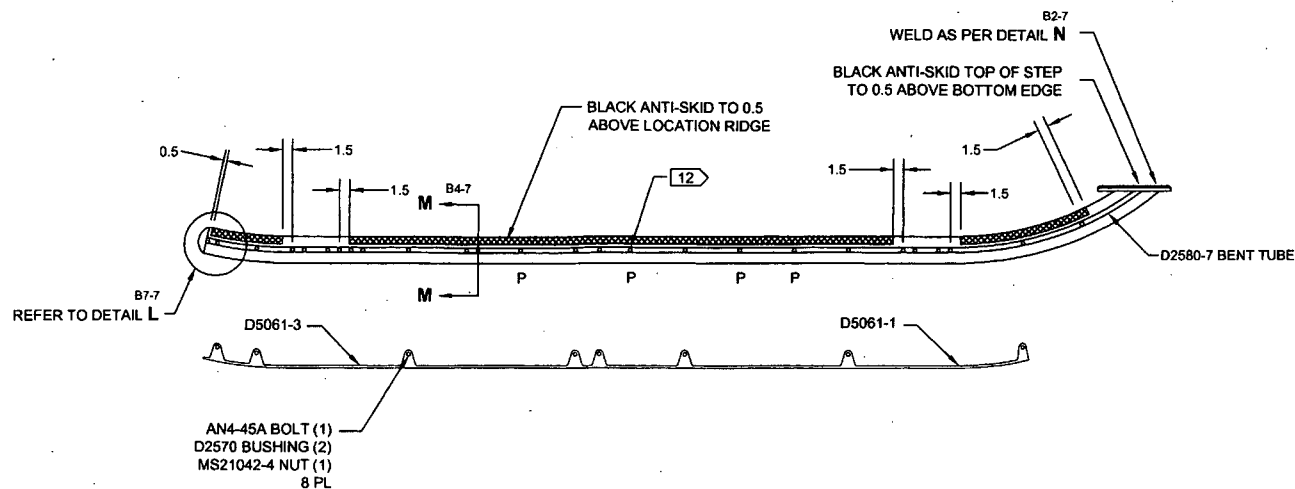
**SECTION I-I** D5-6  
SCALE 5X

- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
  2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
  3. TRIM/GRIND FLUSH PER QSI 002

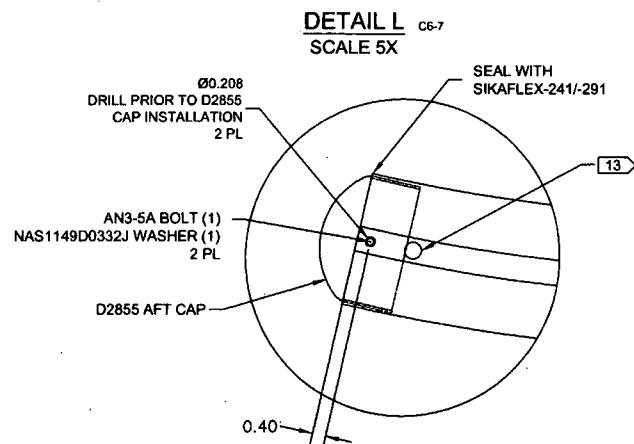


**DETAIL J** D3-6  
SCALE 5X

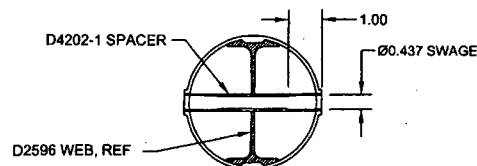
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
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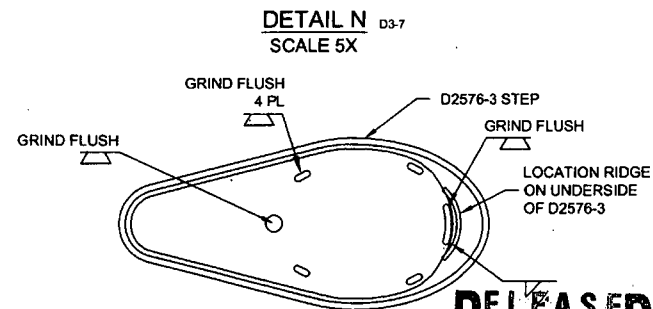
D2580-049 ASSEMBLY DETAIL  $\triangle$  G



SECTION M-M D5-7  
SCALE 5X

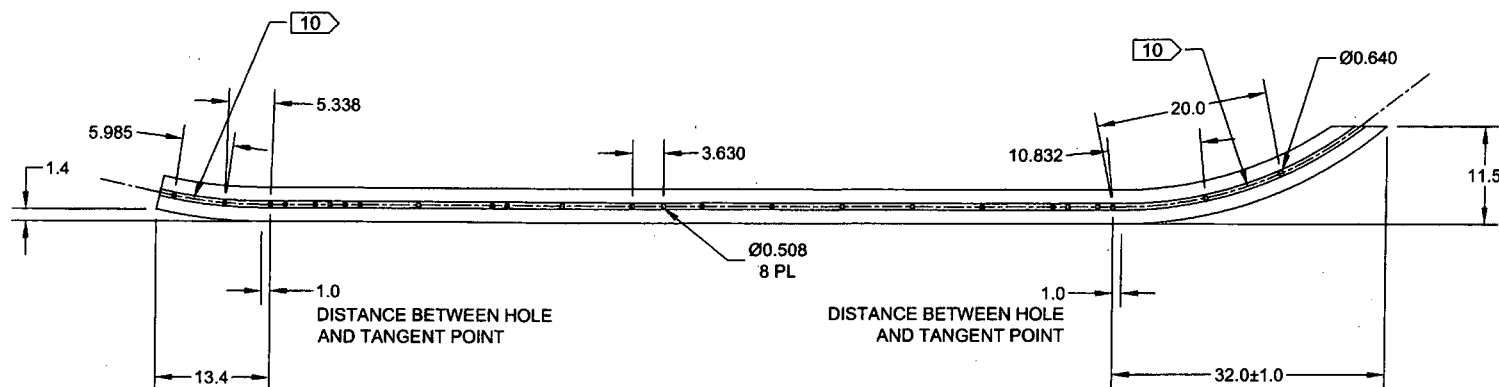


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (24 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM/GRIND FLUSH PER QSI 002



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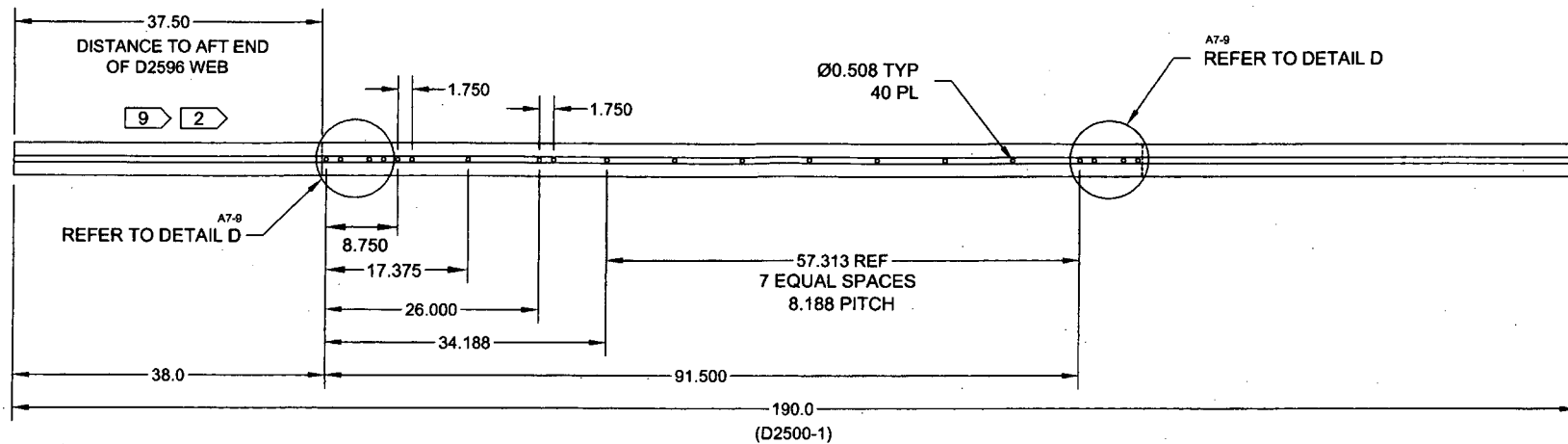
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DATE	14.04.09		



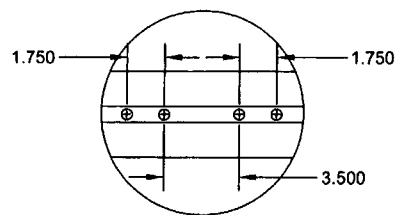
**D2580-7 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

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2014-04-29

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DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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D2580-101 TUBE



**DETAIL D** C3-8  
SCALE 5X C7-8

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le

PAR 14-338  
Patrick Smith  
May-29-14 1:29 PM  
Linda Lacelle; Mike Petsche  
Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd  
RE: 350 skids and 206 skids

David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

Plugs would require:  
oval from the Skidtube  
oval of the current O-Ring  
ning with Alcohol  
allation of NEW O-Ring  
erous coating of the RTV  
rtion of plug into the Spacer  
in up of exterior of Skidtube.

a Lacelle  
29-14 10:21 AM  
itsche  
rbes; Patrick Smith; Eric Downing; Nancy MacLeod  
50 skids and 206 skids  
e: High

terday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution  
this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...